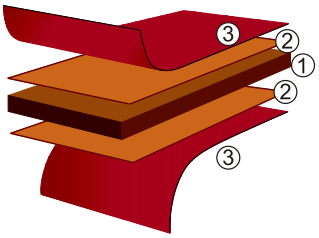
SWISS**PFB**

Rigid composite board of raw particleboard and HDF E1 for indoor use

Characteristics	SWISS**PFB** is a composite board consisting of a **p**articleboard core (P2) and a thin HDF (**f**ibre**b**oard) board glued to the top and bottom. This lends the board greater rigidity. The use of wood from sustainably managed Swiss forests and an environmentally friendly production process provide the basis for a product of Swiss quality. The flat pressed particleboard is made up of three plies with a full, high strength particle ply at the centre. The HDF top ply presents a uniform, resistant surface that lends the composite extremely good rigidity. The adhesive used for the particle- and HDF boards is a urea formaldehyde (UF) resin that provides good mechanical properties. The composite boards are manufactured with a special adhesive system that eliminates the drawbacks associated with conventional production means (setting deformations).
Application	SWISS **PFB** is suitable as a particularly rigid base board for lining furniture surfaces.
Technical class	Core: particleboard (flat pressed) for use in dry areas and nonbearing applications as defined under EN 312, type P2 Surface: high density, dry process fibreboard for use in dry areas and general (nonbearing) applications as defined under EN 662-5, type MDF
Product structure	 Three ply product structure: ¬ Plane, compact surface thanks to homogeneous structure of high density fibreboard (2) ¬ High board core strength thanks to the particle board (1) ¬ A specially developed adhesive provides strong bonds between the boards (high rigidity). ¬ Decorative surface (3)
Processing	¬ SWISS**PFB** can be processed with the usual woodworking tools. ¬ The boards are suitable for lining with laminate, veneer, and decorative paper. This must observe the instructions under *Lignatec, "Holzwerkstoffe in Innenräumen", Zürich 2008* (see "Recommended board linings"). ¬ Fittings can be secured to the sides or on the surface, depending on the board thickness. Drilling, screwing, or gluing is possible. ¬ Before/after processing (prior to installation), the board can be stored horizontally over its whole surface (optimal storage room conditions: 15–25 °C, 45–65% air humidity).
Certificates / labels	Swiss Made Swiss Quality Certified Quality and Environmental Management Low CO_2-production Swiss Wood from sustainable forest management (certificates can be provided upon request)

SWISS KRONO AG
Willisauerstrasse 37
CH-6122 Menznau

Phone +41 41 494 94 94
Fax +41 41 494 94 49

www.swisskrono.ch
info@swisskrono.ch

SWISS KRONO

Product range and specifications

Product range

On request	2790 | 5590 mm x 2060 mm	19, 22, 25 mm
	boards per package	*25, 20, 20*

Delivery of single or packaged boards in accordance with our terms and conditions. www.kronospan.ch --> interiors

Specifications of SWISS**PFB** raw

General and mechanical properties (EN 312)					Compar. value particleboard	Standard
Thickness	19	22	25	mm	19mm P2	EN 324-1
Bulk density	780 ± 3%	770 ± 3%	760 ± 3%	kg/m³	620-680	EN 323
Bending strength	35	30	28	N/mm²	11	EN 310
Modulus of elasticity	4'500	4'300	4'000	N/mm²	1'600	EN 310
Internal bond strength	0.4	0.4	0.4	N/mm²	0.35	EN 319
Surface soundness	1.2	1.2	1.2	N/mm²	0.8	EN 311
Screw withdrawal strength	1200 | 750	1200 | 750	1200 | 750	N (surface | edge)	560 | 700	EN 320
Lindane | Pentachlorophenol (PCP)	n.d | n.d (n.d. = not detected)				Lindane 0 | PCP <5	ChemVerbotV
Formaldehyde content	E1: ≤ 6.5 mg/100 g dry board					EN 120
Formaldehyde emission	E1: ≤ 0.124 mg/m³					EN 717-1
Tolerances	Length x width for 2.79 x 2.06 m and for 5.59 x 2.06 m ±5.0 mm Edge straightness 1.5 mm/m | squareness 2.0 mm/m Bulk density (deviation from mean density inside board) ±10%					EN 324-1 EN 324-2 EN 323

Specifications of melamine-faced SWISS**PFB**

Abrasion resistance	3A	Class		EN 14322
Scratch resistance	2.5	N		EN 14322
Resistance to cracking	5	Level		EN 14322
Impact resistance (large steel ball)	800	mm		EN 14322
Resistance to water vapour	4	Level [1-5]		EN 14322
Color matching	≥ 4	Level [2-5]		EN 14322
Resistance to staining (Group 1 | 2)	4 | 4	Level [1-5]		EN 14322
Light fastness (xenon lamp)	grey 4 / blue 6	Level [1-5]		EN 14322
Formaldehyde emission	<1	mg/m²h		EN 717-2
Tolerances	Thickness ±0.3 mm | thickn. diff. within board ≤0.6 mm | flatness ≤2 mm/m | Length / width for 2.79 x 2.06 m ±3.0 mm, Edge chipping for 2.79 x 2.06 m ≤10 mm, Surface defects: spots ≤2 mm²/m², longitudinal defects ≤20 mm/m			EN 14322
Ecological characteristics Product declaration SIA 493	Renewable energy > 90% | wood fibre 86% | UF-resin 10-12% Swiss wood | local hard- and softwood from forest thinnings and sawmill residues | no post-consumer recycling content | no chlorides no biocides | thermally recyclable			SIA 493.05

Excellent properties


rigid


high bending strength


easy to process


resource friendly


environmentally friendly

Safety and other information

- Due to the high weight, special care must be taken in handling the boards (proper way of lifting, risk of crushing, etc.).
- Processing can give rise to saw- and grinding dust. Do not breathe in this wood dust (protective equipment and suction)! Suction equipment should always be used to remove wood dust. The risk of explosion is therefore minimised.
- The product is not on the list of hazardous substances, nor is it subject to precise labelling requirements (Dangerous Substances Ordinance / Waste Traffic Ordinance).
- The adhesive used in the base board is urea formaldehyde resin. However, there is scarcely any free formaldehyde, and the correctly processed board releases virtually none (E1).
- The product is chemically stable and has no toxic effects. It is suitable for indoor applications.
- SWISS**PFB** is a product from sustainable forest management. The wood used comes from forest thinnings, and so helps to keep Swiss forests healthy.
- The product can be recycled after the first lifecycle or converted into heat in a suitable plant (CO_2 neutral energy).

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